

Date: Thursday, 2/7/2008 8:51:50 AM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : FLOOR DOUBLER

Job Number : 37269

Part Number : D37011

Estimate Number : 13149

Drawing Number : D3701 U/R

P.O. Number :

Project Number : N/A

This Issue : 2/7/2008

Drawing Revision : U/R

Prsht Rev. : NC

Material :

First Issue : / /

Type : R & D SM/MED FAB

Due Date : 2/14/2008

Previous Run : 37135

PROTOTYPE

Written By :

Qty: 1 Um: Each

Checked & Approved By :

Comment : Est Rev:A 08-01-30 new issue DD verified by:EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 M6061T6S080 6061-T6 .080 Sheet



**CERTIFICATE OF CONFORMITY
REQUIRED**

Comment: Qty.: 1.0545 sf(s)/Unit Total : 1.0545 sf(s)
 6061T6 aluminium sheet .080" thick
 (M6061T6S080)

Batch: 104921 HB 8-2-7

2.0 WATER JET FLOW



Comment: FLOW WATER JET

1-Cut as per Dwg D3701

Dwg Rev: UR

Prog Rev: UR

HB 8-2-7

2 prototypls
made?
w/ ~~104921~~ HB 8-2-7

2- Deburr if necessary

HB 8-2-7

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-2-7

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8

SECOND CHECK



**ENGINEERING
APPROVAL**

1

Comment: SECOND CHECK

10/08/08 (X) 2-8-02-07

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

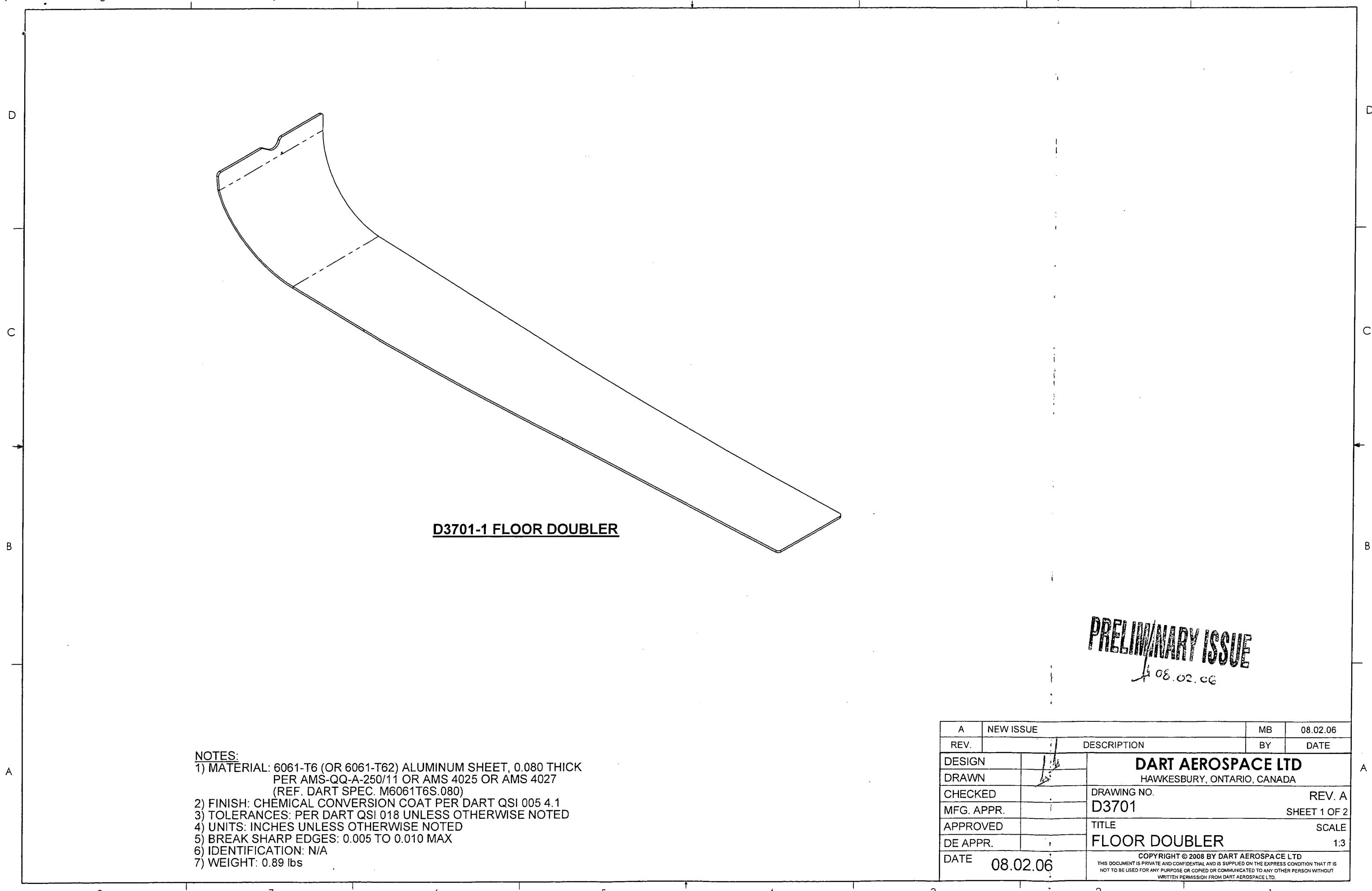
1- Deburr if necessary

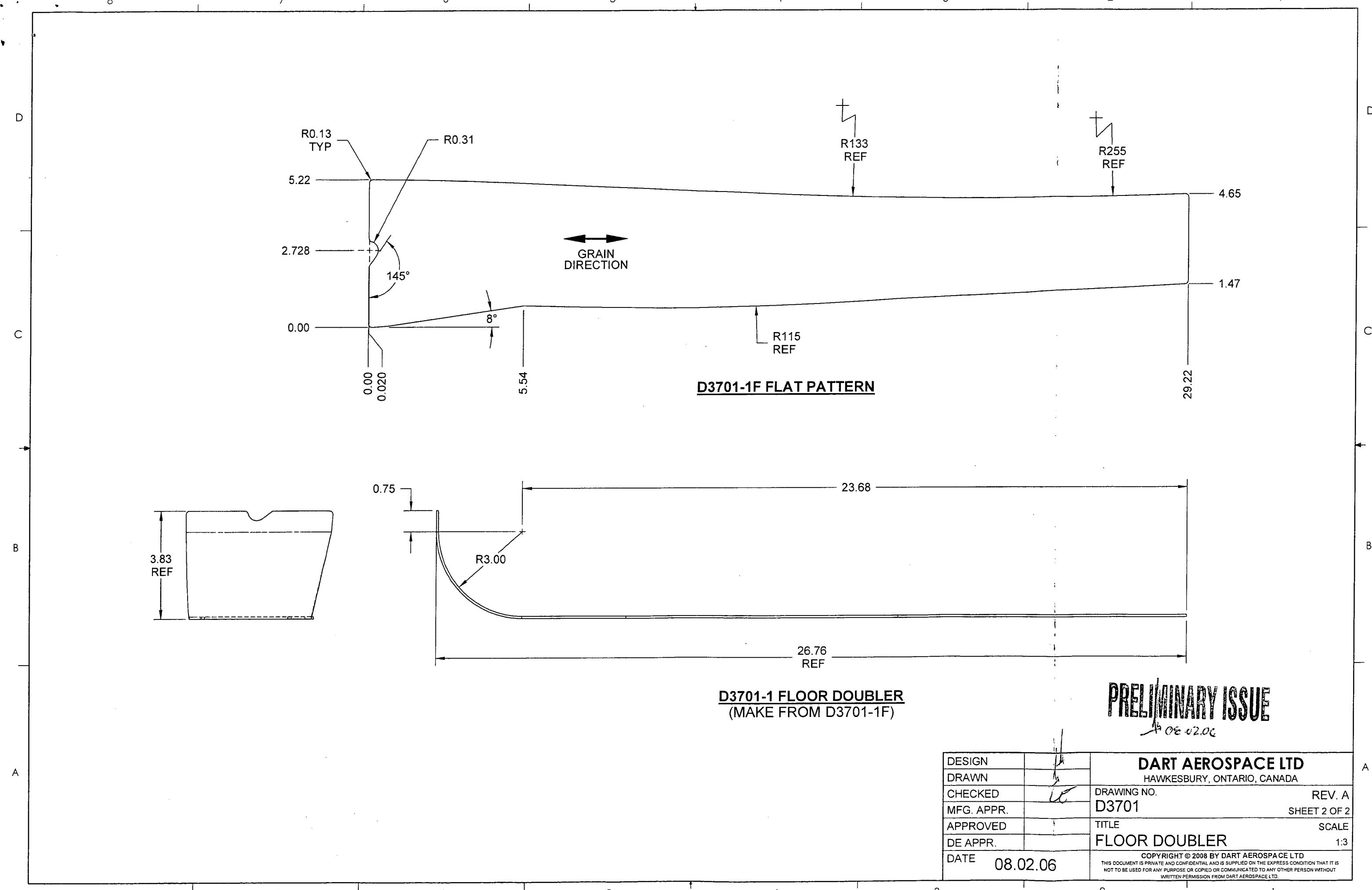
10/08/08 (X) 2-8-02-07

Date: Thursday, 2/7/2008 8:51:50 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: FLOOR DOUBLER
Job Number: 37269		Part Number: D37011
Job Number:		
Seq. #:	Machine Or Operation:	Description :
2- form as per dwg D3701		
6.0	QC5	INSPECT WORK TO CURRENT STEP 
 Comment: INSPECT WORK TO CURRENT STEP		
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <i>180802-20</i>		
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION ENGINEERING APPROVAL 
 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION <i>N/A</i>		
9.0	PACKAGING 1	PACKAGING RESOURCE #1 
 Comment: PACKAGING RESOURCE #1 Identify and Stock FOR ENGINEERING USE ONLY Location: _____ <i>180802-20</i>		
10.0	QC21	FINAL INSPECTION/W/O RELEASE 
 Comment: FINAL INSPECTION/W/O RELEASE <i>180802-20</i>		
Job Completion		 <i>UMF 08-05-16</i>





DART AEROSPACE LTD	Work Order:	37269
Description: FLOOR DOUBLER	Part Number:	D 3701-1
Inspection Dwg: D 3701-1 Rev: U/R		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>HB</u>	Audited by: <u> </u>	Prototype Approval: <u> </u>
Date: <u>8-2-7</u>	Date: <u>08/07/07</u>	Date: <u>06.01.02</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Date: 07/07/09
 Supplier: Campi

Batch No: 1104921
 Dart P/O: 4054

Packing Slip: Yes No
 Invoice: Yes Cr
 Receipt: Cash

Release Note Attached: Yes No N/A
 Waybill Attached: Yes No N/A
 Shipment Complete: Yes No N/A
 QC6 Inspection: OK Defects
 Work Order

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M304B01500X2500	12	0	0	12		
M30452564	32	0	0	32		
M413011B0500X0300	40	0	0	40		

Production/Admin:

07/07/09
BCP 5032
OK

Date Received/Costing
 Initial

Location

Initials of receiver (if shipment OK) Level 12 OK

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

150 377-4248
 150 377-5696

MONTRÉAL : 514 336-4248
 FAX : 514 336-4246

ONTARIO : 1 800 667-4248
 FAX : 1 866 456-4242

DISTRIBUTEUR D'ACIER ET MÉTAUX SPÉCIALISÉS
 STEEL AND SPECIALTY METALS DISTRIBUTOR

On a du Savoir "FER"

FACTURE
 INVOICE

N° 176759

DATE 04/07/07

BON DE LIVRAISON
 PACKING SLIP N° 123473

DATE DE LIVRAISON
 DELIVERY DATE 04/07/07

TERMES / TERMS NET 30 JOURS	REMARQUES / REMARKS		PAGE N° 001	
DESCRIPTION	POIDS WEIGHT	PRIX PRICE	PAR PER *	MONTANT AMOUNT
.080 12'	192	5.700		1094.40
.040 8'	128	2.500		320.00
.063 12'	144	20.500		2952.00
.080 12'	144	25.650		3693.60
X 2.5	0	35.400		0.00
3/8 X .035	120	1.750		210.00
72 X 3	0	31.500		0.00
POIDS TOTAL TOTAL WEIGHT		728.00		

Formplus N° 8619

MATERIALS REMAIN THE PROPERTY OF "ACIER CAMPi INC." UNTIL PAYMENT IS MADE IN FULL, COMPLETE AND CASHED.
 THE BUYER'S EXPENSE. • ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER.
 TO RESPECT THE FOLLOWING CONDITIONS: NET 30 DAYS FROM BILLING DATE AND THE BUYER ACCEPTS TO PAY
 2% PER MONTH OR 24% PER ANNUM ON ALL PAST DUE ACCOUNTS OVER 30 DAYS. • ANY DEFAULT IN RESPECT WITH
 PAYMENT BY ACCELERATION AND PERMITS TO THE SELLER, AT HIS CHOICE TO CLAIM FOR THE BALANCE DUE OR THE
 SOLD. • ANY CLAIM MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT ENCLOSED. • ANY MERCHANDISE
 CUT OR MODIFIED CANNOT BE RETURNED. • ALL GOODS RETURNED MUST BE WITH OUR AUTHORIZATION AND ARE
 CHARGE.

EN BONNE CONDITION MERCHANDISE RECEIVED IN GOOD CONDITION

A/Y	M/M	J/D

U CLIENT / CUSTOMER'S SIGNATURE

DATE

SOUS-TOTAL SUB TOTAL	8270.00
T.P.S. G.S.T.	496.20
T.V.Q. Q.S.T.	0.00
TOTAL	8766.20

CERTIFIED INSPECTION REPORT

We hereby certify that the material covered by this certificate has been inspected and has been found to meet the applicable quality requirements detailed herein, including any specifications having a part of the description and has samples representative of the material and the sample taken from and had the dimensional properties shown on the face of this sheet.

Mark J. Vitello

Mark J. Vitello
Director of Manufacturing Overhead Works

Karen Young

Karen P. Young
Quality Assurance Manager

Ship From:

731866 0
Ship Date B.L. No. Invoice No. Alena No. Item
2007-02-19 2082189 00000 4437904-1
P.O. No./Govt Contract No. Customer Mfg Order

Page 1

W612428
our PO 86672.

on 07/07/06

Ship To:

Item Description
0.08 IN. TK (+0 -.0065) X 48.9 IN. 4-14-046875
.016075) CAT X G0415462R03 (N/A/T-0461-16
COIL SHEET FOR DISTRIBUTORS TOLERANCE GUARANTEED. AMS-QQ-A-
250/11 AMS4027 REV M AMSH35.2 REV 2006 ASME-SB-
209 REV A99 ASTM8209 REV 06 (NOT
MARKED) LIGHTLY OILED COIL SIZES: ID 20 IN
COIL WTGS: MAX 6500 LB
MAX GROSS SKID WTG: 7000 LB QUAN TOL +/-10
CQR D138487 REV 31 CUST REQ 07-02-
17 *** H/B 07-02-24 ***

Num	Package	Ticket	Lot	Weight	Quantity	UOM	PC Id/Serial
1		492938	555793	4861	1	PC	DO35909
2		496818	597268	6410	1	PC	DO35908
				11271	2		

Notes for CQR: D138487.31

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/11 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/11P. PROD UCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/11 P ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/11.

CQR: D138487.31 -Specification Limits

Impr	Dir	UTS	TYS	ELAD
		KSI	KSI	PCT
T6	Long Transv.	Max		
		42.0	35.0	10
		Min		

Chemical Composition	Si	Pb	Cu	Mn	Ni	Cr	Zn	Tl	Other	Other
	Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05
Alloy 6061	Max									0.15
Lot: 555793	Min	0.40	0.15	0.8	0.04					RECALL

- Mechanical, Physical, Metallurgy, Quantometer Results

No->	UTS	TYS	ELAD	
Impr	Test	KSI	PCT	
T6	2	49.7	44.7	11.1

CERTIFIED INSPECTION REPORT

We hereby certify that the material covered by this certificate has been inspected and has been found to meet the applicable requirements described therein, including any specifications listing in part of the description and that samples representative of the material meet the composition limits and had the mechanical properties shown on the face of this sheet per:

Mark J. Vrable
Director of Manufacturing Diversified Metals

Kristin P. Young
Quality Assurance Manager

Ship From: RIVERDALE, IA.

Page: 2

731866	0	Invoice No.	Alcoa No. Item
Ship Date	B.L. No.		
2007-02-19	2081389	00000	4437904-1
P.O. No./Govt Contract No.		Customer	Ufa Order
		M612428	SAMUEL SON & CO LT DS-37904-1

Lot: 555791 - Mechanical, Physical, Metallography, Quantometer Results (cont.)

19.6	44.5	11.6
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Cast Number Chemical Si Fe Cu Mn Ni Cr Mn Ti
06J06551 Actuals 0.62 0.5 0.28 0.01 0.9 0.19 0.02 0.02

Lot: 587268 - Mechanical, Physical, Metallography, Quantometer Results

Tmpr	Dir	No. >	UTS	TYS	ELAD
Test			KSI	KSI	PCT
Ts	Long Transv.	2	49.8	45.1	10.8
			49.6	44.8	11.4

Cast Number Chemical Si Fe Cu Mn Ni Cr Mn Ti
M8522033 Actuals 0.64 0.4 0.25 0.06 1.0 0.20 0.02 0.02

D 035909

D 035908